

Work Order ID 134027

134027

Page 1

Wednesday, June 24, 2015 11:44:28 AM

Item ID: D2855 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 6/24/2015 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 6/24/2015 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUN 24 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2855	Rev B								

100 PURCHASING 0.00
 100 Purchasing Memo 0.00
 Purchasing Issue P/O: 28958 Cast per Dwg D2855 Material Release Note
 Required Supplier: Metallurgie SYCA

CX JUN 26 2015 40

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110 Packaging Memo 0.01
 Packaging Ensure Material Release Note is attached

40X SP15-07-17

120 QC6- Inspect dimensions to drawing 0.00
 120 QC Memo 0.00
 Quality Control

(4/0) 38
9-89

JUL 21 2015

Work Order ID 134027

Wednesday, June 24, 2015 11:44:28 AM

134027

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab				DAS				JUL 22 2015
Small Fab	Memo	0.03			30	40			
Small Fab	1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr				9-89				
140		0.00							
140	QC5- Inspect part completeness to step on W/O								DAS
QC	Memo	0.01							38
Quality Control									9-89
									JUL 24 2015
150		0.00							
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum								
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 11:15. OVEN TEMPERATURE: 320° FINISH TIME: 11:45.								
									40 6/15-8-26. DAS 34 9-89

Work Order ID 134027

Wednesday, June 24, 2015 11:44:28 AM

134027

Page 3

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.01							
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.02							
Small Fab	Install Inserts as per Dwg D2855								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.01							
Quality Control									

DAS
15
9-89

28
34
9-89

Work Order ID 134027

134027

Page 4

Wednesday, June 24, 2015 11:44:28 AM

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location <u>FP-001</u>	0.00							
190									
Packaging	Memo	0.01							
Packaging	LOCATION : FP001								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.07							
Quality Control									

20150827
 SA

Picklist Print

Wednesday, June 24, 2015 11:44:32 AM

Page 1

Work Order ID: 134027

134027

Parent Item: D2855

D2855

Parent Item Name: Cap

Start Date: 6/24/2015

Required Date: 6/24/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat
EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No			100	Each	330.0000	2	80			

AI S7-1032-225

Insert

all 6/24/26

Location

Loc Qty

Loc Code

cck3

210

m131657

210

FG

120

118520

120

D2855P

Purchased

No

170

Each

0.0000

1

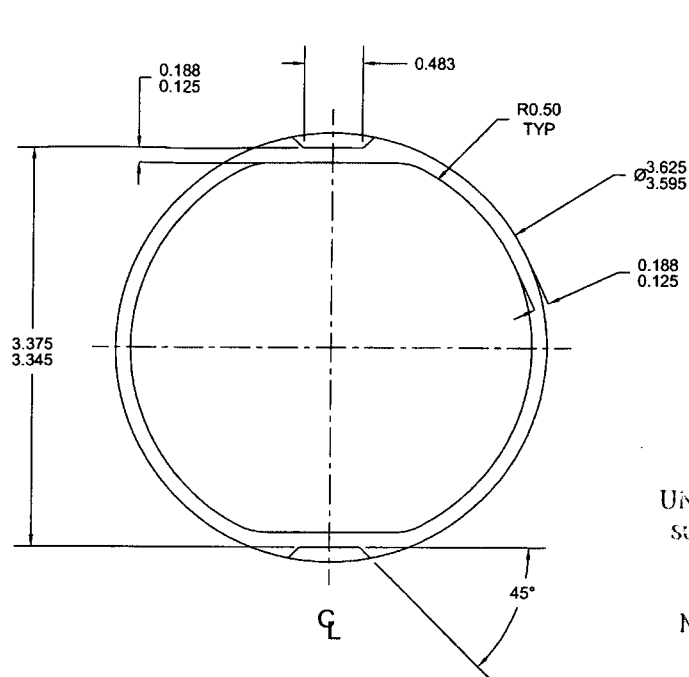
40

D2855P

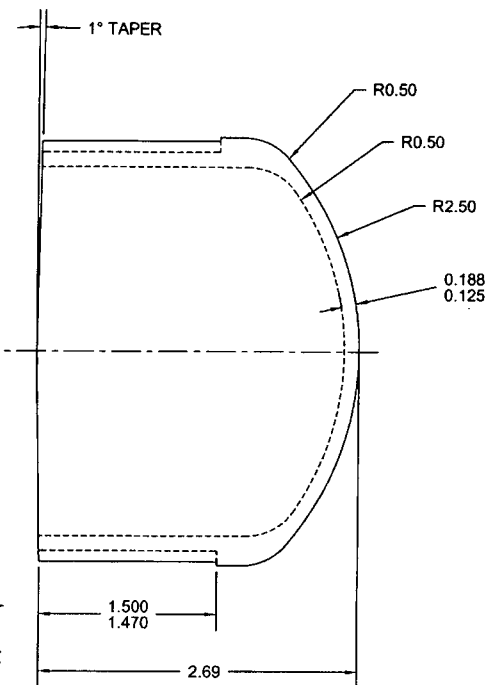
Cap

40x 5015077

M132777



SHOW COPY
RETURN TO
SOURCE
UNCONTROLLED COPY
SUBJECT TO DISCREPANCY
WITHOUT NOTICE
WORK ORDER
NO. 134027.MLS
1506-24



D2855C CASTING DETAIL



NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

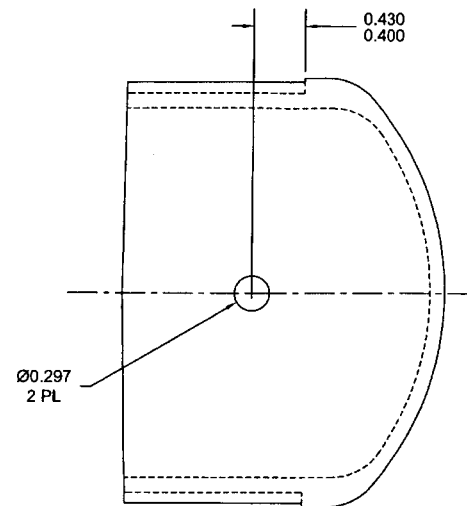
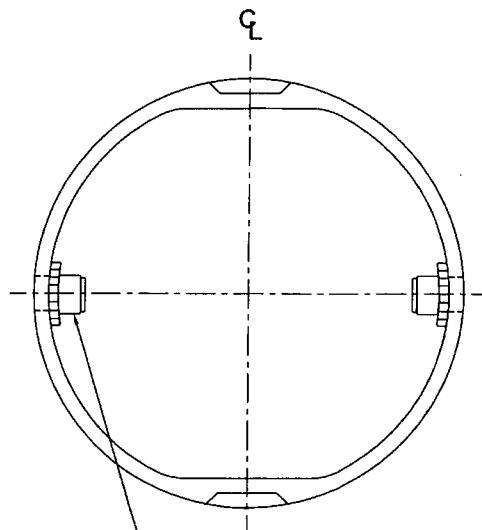
RELEASED
09/15/15 ML

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.06.30		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D2855 SHEET 1 OF 3
TITLE SCALE
CAP NTS

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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

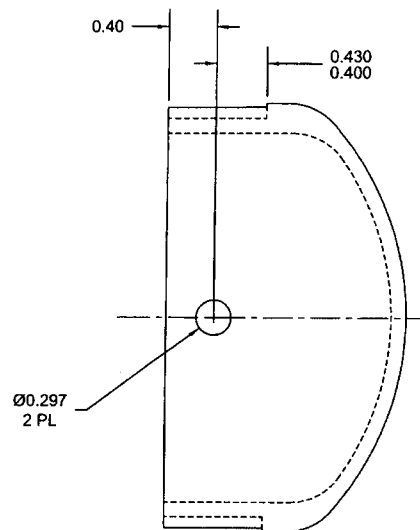
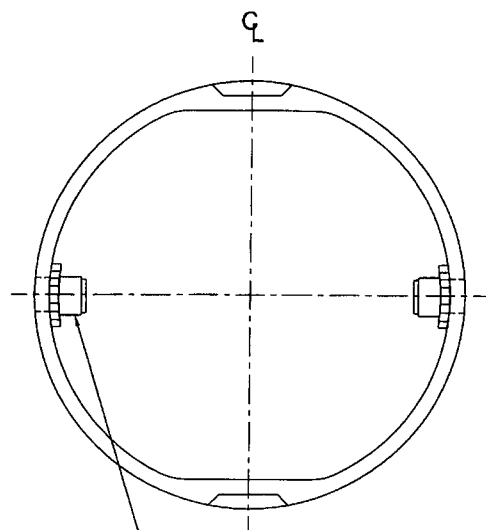
D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
21/07/15

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28958**

Purchase Order Date 6/26/2015 8:41:33 AM

PO Print Date 6/26/2015

Page Number 1 of 2

Order From :

VC-MSY01

METALLURGIE SYCA
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-261-0853

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P AS PER DWG D2855 REV. B BT34027 X 40 PCS BT33972 X 10 PCS	Cap	7/24/2015 Yes 7/24/2015		50.00 Each	\$12.50	\$625.00
Line Total:							\$625.00
4	71401-45 PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS	PROCUREMENT QUALITY CLAUSES	7/24/2015 No 7/24/2015		1.00 ✓	\$0.00	\$0.00

PO Instructions: Fedex Acc#151793240

Note:

6/26/2015

MÉTALLURGIE SYCAINC
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE PO 28958 DATE 14-07-2015

ORDER NO. DATE
VENDU À DART AEROSPACE LTD.

SOLD TO DART AEROSPACE LTD.
ADRESSE 1270 ABERDEEN STREET

ADDRESS 1270 ABERDEEN STREET
EXPÉDIÉ À HAWKSBURY, ONT

SHIP TO HAWKSBURY, ONT
ADRESSE K6A-1K7

ADDRESS K6A-1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDUEUR
SALESPERSON

52

D-2855

1 BOX X 52 Pcs X 28 Pounds

AX 8015-07-17

TRANSPORT FEDEX

THANKS FOR YOUR SUPPORT

TOTAL

551906

SIGNATURE

Blueline DCB27

FORMULAIRE DE VENTE - SALES ORDER

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